



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

18/11/14
646.9710

Job Sheet 185799



Part No: 646.9710

Job Qty: 40 ea

Part Name: Body



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/2/18

Job Tracking No:

Due Date: 11/16/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV E SHEETS 1-4 IPP REV:A NEW ISSUE 12/10/04 JFS VERIFY BY: DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Lead Time	DAS Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier			
90	Start up Operation	10 Ea	11/16/18	11/16/18	0.00	0.00	Start Up Machining-1			52 18/11/14
110	CNC Vertical Machining	10 pcs	11/16/18	11/16/18	0.22	5.00	HAAS1-1			9-89 18/11/14
120	QC	10 pcs	11/16/18	11/16/18	0.00	0.00	QC2 Machining-1			18/11/14
130	QC	10 pcs	11/16/18	11/16/18	0.00	0.00	QC8 Machining-1			18/11/14
140	Outsource	10 pcs	11/16/18	11/16/18			ATG001-VC	10		DEC 18-11-2018
150	Packaging	10 pcs	11/16/18	11/16/18	0.00	0.00	Packaging2			DEC 18-11-2018
155	QC	10 pcs	11/16/18	11/16/18	0.00	0.00	QC6			61
160	SprayPaint	10 pcs	11/16/18	11/16/18	0.00	1.67	Spray Paint			9-89
165	QC	10 pcs	11/16/18	11/16/18	0.00	0.00	QC14			6
180	Packaging	10 pcs	11/16/18	11/16/18	0.00	0.00	Packaging3-1			9-89
190	QC21-SA	10 Ea	11/16/18	11/16/18	0.00	0.00	QC21			9-89

Part Op 90 - Cut Blank at 7.425"

Descriptions: 110 - 1-Machine per folio FB130

140 - Issue P/O to ATG : _____ Hard Black Anodize Color Black and Prime as per Dwg 646.9700

180 - ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M7075T6S1.000X5.000	7075-T6 Sheet1" Thick Plate X 5" Wide	6.2100 ft (.621 ea)	90-Start up Operation	5129443

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M7075T6S1.000X5.000	6	7	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Body	0.130Inches $\pm$ 0.010	0.140 0.120	0.130	
2	Body	45.0Angle $\pm$ 0.5	45.5 44.5	45°	
3	Body	1.500Inches $\pm$ 0.005	1.505 1.495	1.500	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____		DISPOSITION		AGAINST DEPARTMENT/PROCESS																																																							
Part No. _____		Rework ☐ Scrap ☐ Use-as-is ☐		Skid-tube Machining ☐ Thermoforming ☐ Large Fab ☐		Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐		Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐		Engineering ☐ Quality ☐ Other ☐																																																	
NCR No. _____		Suspected Unapproved ☐		QTY Effective: _____						MRB (QSI042) Approval ☐																																																	
Date: _____		Step #: _____		Disposition																																																							
Description Work Order Deviation																																																											
Completed By Lead hand / Supervisor Approval Verification																																																											
QC / QA Coordinator Approval																																																											
Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL.: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com Date: 11/24/18																																																											
Root Cause<table border="1"><tr><td>Environment</td><td>☐</td><td>No Re-verification</td><td>☐</td></tr><tr><td>Design</td><td>☐</td><td>Operator</td><td>☐</td></tr><tr><td>Doc/Data</td><td>☐</td><td>Offset/Setup</td><td>☐</td></tr><tr><td>Equip/Tooling</td><td>☐</td><td>Supplier</td><td>☐</td></tr><tr><td>Handling/Pre</td><td>☐</td><td>Training</td><td>☐</td></tr><tr><td>Material</td><td>☐</td><td>Use for Test</td><td>☐</td></tr><tr><td>Internal Transport</td><td>☐</td><td>Poor Inform</td><td>☐</td></tr><tr><td>Tribal Knowledge</td><td>☐</td><td>Rushing</td><td>☐</td></tr><tr><td>LOA</td><td>☐</td><td>Product Improvement</td><td>☐</td></tr><tr><td>Substation</td><td>☐</td><td>Process Improvement</td><td>☐</td></tr><tr><td>Past Expiry Date</td><td>☐</td><td>Manufacturing Process</td><td>☐</td></tr><tr><td>Misidentified</td><td>☐</td><td>Past Due</td><td>☐</td></tr></table> Container No: S131228 Part: 646.9710 Job No: 185799 Serial No/Batch: S131228 Revision: E Inspector: Exp Date: Instructions: Large 1 Pulled in												Environment	☐	No Re-verification	☐	Design	☐	Operator	☐	Doc/Data	☐	Offset/Setup	☐	Equip/Tooling	☐	Supplier	☐	Handling/Pre	☐	Training	☐	Material	☐	Use for Test	☐	Internal Transport	☐	Poor Inform	☐	Tribal Knowledge	☐	Rushing	☐	LOA	☐	Product Improvement	☐	Substation	☐	Process Improvement	☐	Past Expiry Date	☐	Manufacturing Process	☐	Misidentified	☐	Past Due	☐
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Misidentified	☐	Past Due	☐																																																								
Wave/Twist in Tube ☐ Marks/Chatter ☐ Drill Holes ☐ Misaligned/off center ☐ Turning Sequence ☐ OTHER: _____																																																											

4	Body	0.352Inches + 0.005 - 0.000	0.357 0.352	0.352
5	Body	0.100Inches ± 0.010	0.110 0.090	0.100
6	Body	45.0Angle ± 0.5	45.5 44.5	45°
7	Body	0.875Inches ± 0.005	0.880 0.870	0.874
8	Body	0.700Inches ± 0.005	0.705 0.695	0.699
9	Body	5.500Inches ± 0.005	5.505 5.495	5.500
10	Body	0.660Inches ± 0.005	0.665 0.655	0.660
11	Body	0.660Inches ± 0.005	0.665 0.655	0.656
12	Body	0.278Inches ± 0.002	0.280 0.276	0.278
13	Body	0.339Inches ± 0.002	0.341 0.337	0.339
14	Body	0.352Inches ± 0.002	0.354 0.350	0.352
15	Body	0.372Inches ± 0.002	0.374 0.370	0.372
16	Body	1.067Inches ± 0.002	1.069 1.065	1.067
17	Body	2.608Inches ± 0.002	2.610 2.606	2.608
18	Body	2.750Inches ± 0.002	2.752 2.748	2.750
19	Body	2.892Inches ± 0.002	2.894 2.890	2.892
20	Body	3.348Inches ± 0.002	3.350 3.346	3.348
21	Body	3.597Inches ± 0.002	3.599 3.595	3.597
22	Body	3.847Inches ± 0.002	3.849 3.845	3.847
23	Body	0.351Inches ± 0.002	0.353 0.349	0.351
24	Body	0.544Inches ± 0.002	0.546 0.542	0.544
25	Body	2.195Inches ± 0.002	2.197 2.193	2.195
26	Body	2.304Inches ± 0.002	2.306 2.302	2.304
27	Body	2.451Inches ± 0.002	2.453 2.449	2.451
28	Body	2.639Inches ± 0.002	2.641 2.637	2.639
29	Body	3.395Inches ± 0.002	3.397 3.393	3.395
30	Body	3.495Inches ± 0.002	3.497 3.493	3.495
31	Body	4.551Inches ± 0.002	4.553 4.549	4.551
32	Body	4.595Inches ± 0.002	4.597 4.593	4.595
33	Body	4.687Inches ± 0.002	4.689 4.685	4.687
34	Body	4.734Inches ± 0.002	4.736 4.732	4.734
35	Body	6.651Inches ± 0.002	6.653 6.649	6.651
36	Body	0.201Inches + 0.005 - 0.001	0.206 0.200	0.202

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____		Step # : _____		QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation				Disposition			
				Completed By			
				Lead hand / Supervisor Approval Verification			
				QC / QA Coordinator Approval			

Root Cause		FAULT CATEGORY									
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Broken/Damage/Defect	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Contamination	☐	Out of Sequence	☐	Part Lost/Missing	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Countersink	☐	Off-set	☐	Part Moved	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Cut Too Short	☐	Mislabeled	☐	Drawing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Finish	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Drill Holes	☐	Misaligned/off center	☐	Misread	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐		☐		☐	Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process	☐		☐		☐		☐		☐
Misidentified	☐	Past Due	☐		☐		☐		☐		☐
OTHER : _____											

37	Body	0.177Inches + 0.005 - 0.001	0.182 0.176	0.178
38	Body	7.026Inches ± 0.005	7.031 7.021	7.027
39	Body	4.245Inches ± 0.005	4.250 4.240	4.246

Plex 11/2/18 10:18 AM Dart.lajeunesse.marie

DQA: _____ Date: _____

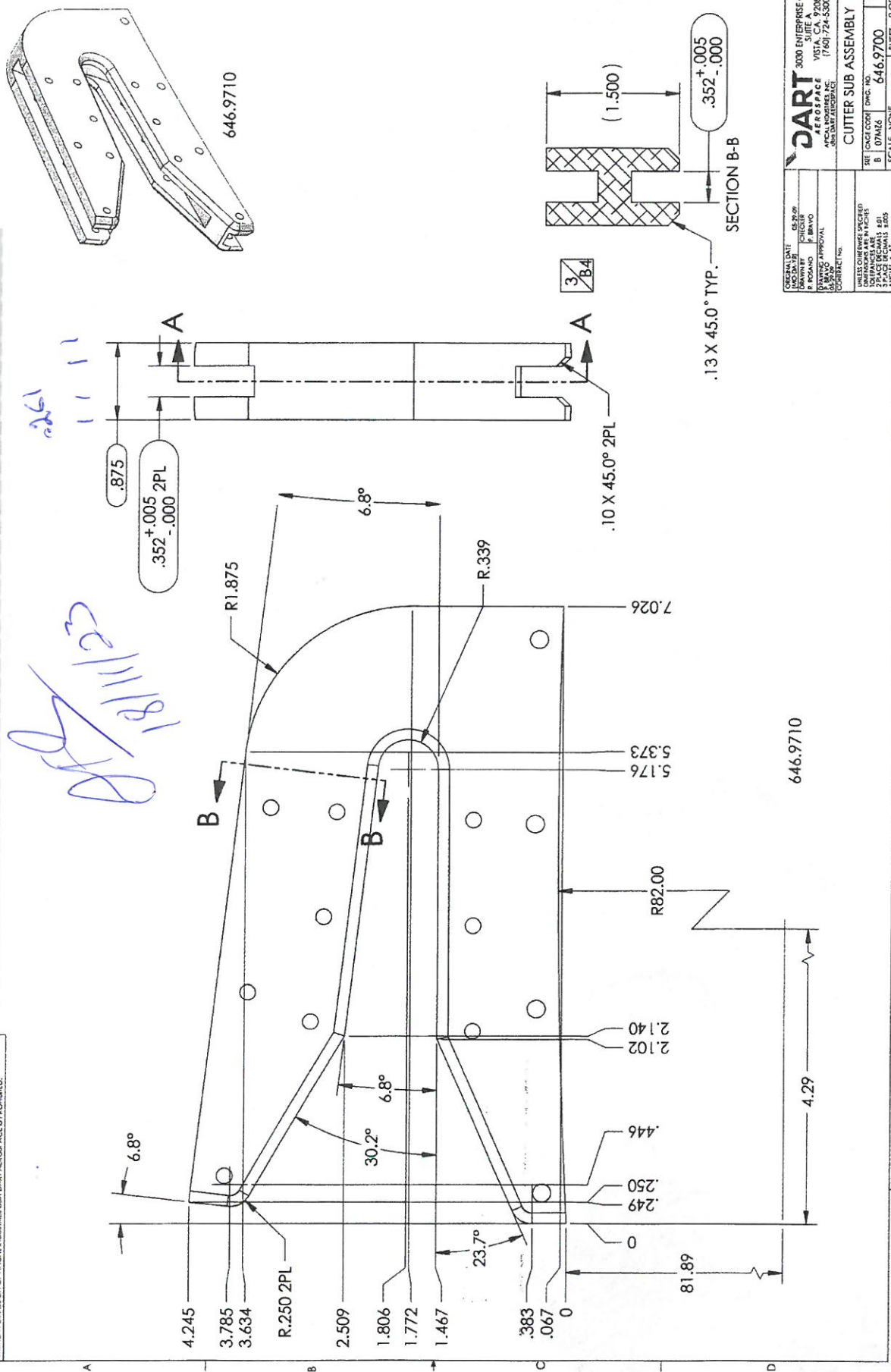
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube Machining ☐ Thermoforming Large Fab ☐ Cross tube Small Fab ☐ Finishing Composite ☐ Water Jet Prod. Eng. Coord. ☐ Rec/Store/Packaging Supplier ☐ Engineering Quality Other ☐			
Date : _____		Step #: _____		QTY Effective : _____			
Description Work Order Deviation		Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐		FAULT CATEGORY No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐ Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐					
OTHER : _____		Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____					

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M7075T6S1.000X5.000
S129443

10



646.9710

DATE	05-27-98
OWNER	CHIEF
PILOT	PIANO
ADDRESS	10000 W. 10TH AVE. S.W.
CITY	IRVING, TEXAS
STATE	TX
ZIP	75039
PHONE	(972) 440-1111
FAX	(972) 440-1111
TELETYPE	
TELEFAX	
EMAIL	
WEBSITE	
DESCRIPTION	10000 W. 10TH AVE. S.W. IRVING, TEXAS 75039
REMARKS	
DATE	05-27-98
OWNER	CHIEF
PILOT	PIANO
ADDRESS	10000 W. 10TH AVE. S.W.
CITY	IRVING, TEXAS
STATE	TX
ZIP	75039
PHONE	(972) 440-1111
FAX	(972) 440-1111
TELETYPE	
TELEFAX	
EMAIL	
WEBSITE	
DESCRIPTION	10000 W. 10TH AVE. S.W. IRVING, TEXAS 75039
REMARKS	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041883**

Supplier: ATG001-VC
A.T.G. Industries Inc
731 INDUSTRIELLE ROAD
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

Attention: Lalande, Marc-Andre

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO041883
PO Date: 11/28/18
Due Date: 12/11/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Tsimiklis, Chrisoula
Via: Ground
Pynt Terms: Net 30
Freight Terms:
Special Comments:

* revised PO

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	178970	RBE703A94-1130-01-27	Tab Adjuster Body -Issue P/O to ATG: ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1 Water seal -Certificate of Conformity is required	Firmed	-	11/30/18	5 pcs	0 pcs	5 pcs	\$5.80/pcs	\$29.00
5 X NOV 30 2018											
Line Item Note ** ASAP by Friday morning **											
2	184442	RBT18601	Main Rotor Swashplate ReGreasing Tool -Issue P/O to ATG; PO -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant -Material type; -Certificate of Conformity is required	Firmed	-	11/30/18	8 pcs	0 pcs	8 pcs	\$5.80/pcs	\$46.40
8 X NOV 30 2018											
Line Item Note ** ASAP by Friday morning **											



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PURCHASE ORDER **PO041883**

Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	185913	C45-1-1	Manual Knob Release -Issue P/O to ATG; PO -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant -Material type; 6061 -Certificate of Conformity is required As Per DWG C45-1-1	Firmed	-	11/30/18	10 pcs	0 pcs	10 pcs	\$5.80/pcs	\$58.00
Line Item Note ** ASAP by Friday morning **											
4	185767	646.3812	Gusset Bracket Issue P/O to ATG: AS PER MPP-172 SECTION 2.1, HARD ANODIZE COLOR BLACK, PER IAW MIL-A-8625 TYPE 3 CLASS 2 AS PER MPP-172 SECTION 4.3, PRIME CARDINAL 7760-4702 LOW VOC EPOXY PRIMER (LIGHT GRAY) Certification of Conformity is required	Firmed	-	12/5/18	20 pcs	0 pcs	20 pcs	\$7.20/pcs	\$144.00



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PURCHASE ORDER **PO041883**

Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
5	185768	646.3813	AS350 Strut Bracket Issue P/O to ATG: AS PER MPP-172 SECTION 2.1, HARD ANODIZE COLOR BLACK, PER IAW MIL-A-8625 TYPE 3 CLASS 2 AS PER MPP-172 SECTION 4.3, PRIME CARDINAL 7760-4702 LOW VOC EPOXY PRIMER (LIGHT GRAY) Certification of Conformity is required	Firmed	-	12/5/18	20 pcs	0 pcs	20 pcs	\$7.20/pcs	\$144.00
6	186252	650.9201	Eyelet Bracket Assembly Issue P/O to ATG : Hard Anodize, Color Black and Prime as per Dwg 650.9200	Firmed	-	12/6/18	20 pcs	0 pcs	20 pcs	\$7.70/pcs	\$154.00
7	186245	646.3610	Filler Issue P/O to ATG : 1- Hard Anodize Black and Prime as per Dwg 646.3600	Firmed	-	12/11/18	16 pcs	0 pcs	16 pcs	\$7.70/pcs	\$123.20



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PURCHASE ORDER **PO041883**

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
8	185766	646.3810	Bracket Issue P/O to ATG: AS PER MPP-172 SECTION 2.1, HARD ANODIZE COLOR BLACK, PER IAW MIL-A- 8625 TYPE 3 CLASS 2 AS PER MPP-172 SECTION 4.3, PRIME CARDINAL 7760-4702 LOW VOC EPOXY PRIMER (LIGHT GRAY) Certification of Conformity is required	Firmed	-	12/5/18	20 pcs 21	0 pcs	20 pcs	\$7.65/pcs	\$153.00
9	185799 185794-A	646.9710	Body Issue P/O to ATG : Hard Black Anodize Color Black and Prime as per Dwg 646.9700	Firmed	-	12/6/18	10 pcs 10	0 pcs	10 pcs	\$15.60/pcs DAS 61 9-89	\$156.00
10	186661	RBT112800-1	Base -Issue P/O to ATG: ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1 WATER SEAL As per Dwg RBT112800 Rev. 3A -Certificate of Conformity is required	Firmed	-	12/6/18	13 pcs 13	0 pcs	13 pcs	\$5.80/pcs	\$75.40
Grand Total: \$1,083.00											



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PURCHASE ORDER
PO041883

Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 11/30/18 10:12 AM dart.tsimiklis.chrisoula



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 916824

Date: 17-Dec-18

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Chrisoula Tsimiklis
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
10 ea	Part: 646.9710 ✓ Rev: D Body Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0001-.0002" (1 - 2 mils) per drawing. Job: 24232 PO: PO041883 ✓ Line: 9		
DAS 61 9-89			
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: 17/12/2018 Certified Signature: Receiver Signature: _____ A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.			
Made in Canada.			

